

54394 Dargan

Work Order ID 53502

November 6, 2009 11:23:18 AM



Item ID: D3443-9

Revision ID: C

Item Name: Pin

Start Date: 06/11/2009 Start Qty: 10.00

Required Date: 13/11/2009 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: *[Signature]*

Date: *02/11/07*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3443 | Rev C | | | | | | | | |

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

SHOUI 12/07

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA698 & DWG D3443, □ FOLIO
REV: C □ DWG REV: C □ 2-DEBURR AS REQUIRED

10 *[Signature]*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

SHOUI 12/07

Quality Control

10 *[Signature]*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

SHOUI 01/12/07

Quality Control

10 *[Signature]*

Work Order ID 53502

November 6, 2009 11:23:18 AM



Page 2

Item ID: D3443-9

Accept



Setup Start



Revision ID: C

Stop



Item Name: Pin

Start Date: 06/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

19/11/08 (10)

09/12/08

NF
09-12-08

Picklist Print

November 6, 2009 11:23:22 AM

Page 1

Work Order ID: 53502



Parent Item: D3443-9RevC



Parent Item Name: Pin

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

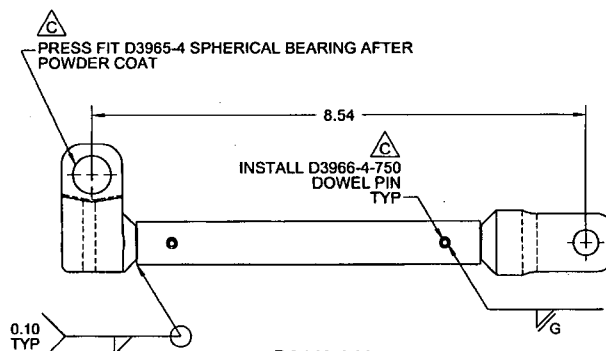
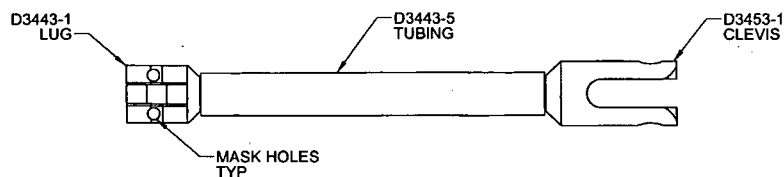
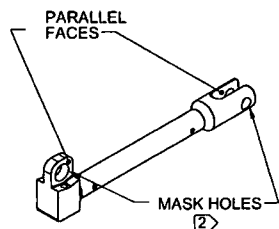
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| MDELNRINR0.500 | | Purchased | No | | | 110 | f | 122.8000 | 0.9211 | | | |



Delrin Round Bar .50"

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 122.8 | |
| 102828 | 4.91 | |
| 105353 | 6.39 | |
| — 109571 | 43.8 | |
| 18355 | 64 | |
| 3723 | 3.7 | |

975 5A091267



D3443-041

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-------------|-------------------------|
| 1 | X | D3443-041 | STRUT WELDMENT ASSEMBLY |
| 2 | 1 | D3443-1 | LUG |
| 3 | 1 | D3443-5 | TUBING |
| 4 | 1 | D3453-1 | CLEVIS |
| 5 | 1 | D3965-4 | BEARING, SPHERICAL |
| 6 | 2 | D3966-4-750 | PIN, DOWEL |

SHOP COPY
 REFERENCE
 ENGINEER'S
 UNCONTROLLED
 SUBJECT TO A
 WITHOUT
 WORK ON
 NO. **53502**
AL09-11-6

RELEASED
09/06/25 MP

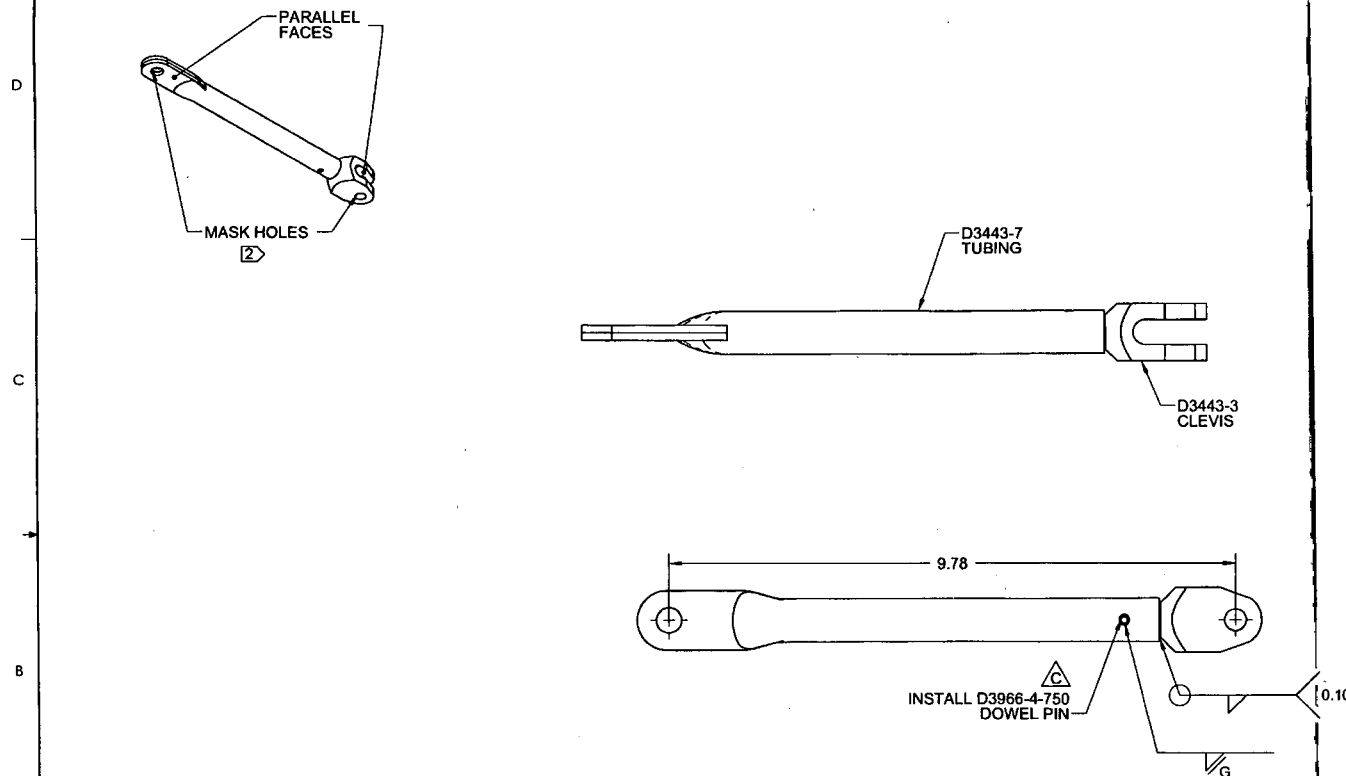
| | | | | | |
|------------|---|--|--------------|----|----------|
| C | DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN AB-1, AB-2); 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0 219 WAS R0 050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS McMASTER-CARR P/N (ZN B5-1); REF PAR 09-018 | | | RF | 09.06.25 |
| | ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø0.125 WAS #30 | | | RF | 05.12.05 |
| | NEW ISSUE | | | RF | 05.09.02 |
| | REV. | DESCRIPTION | | | BY |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | RF | | | | |
| CHECKED |  | DRAWING NO. | REV. C | | |
| MFG. APPR. |  | D3443 | SHEET 1 OF 4 | | |
| APPROVED |  | TITLE | SCALE | | |
| DE APPR. |  | STRUT WELDMENT ASSEMBLY NTS | | | |
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8 7 6 5 4 3

2

1

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-------------------------|
| 1 | X | D3443-043 | STRUT WELDMENT ASSEMBLY |
| 2 | 1 | D3443-3 | CLEVIS |
| 3 | 1 | D3443-7 | TUBING |
| 4 | 1 | D3966-4-750 | PIN |





D3443-043

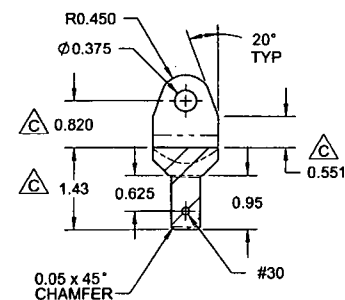
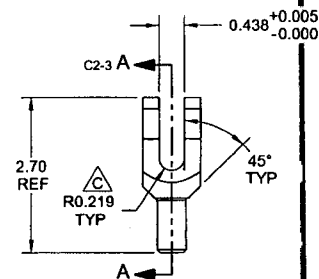
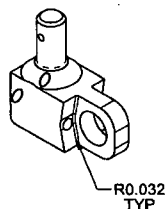
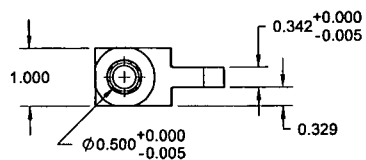
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NOTES:

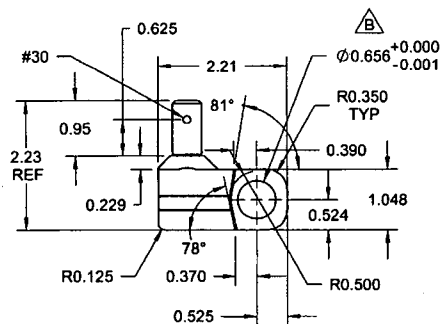
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

| | | | |
|---|---|--|--------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
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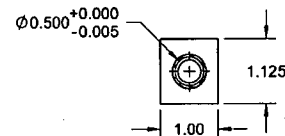
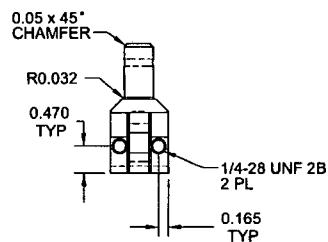
8 7 6 5 4 3 2 1



SECTION A-A C4-3



D3443-1 LUG





D3443-3 CLEVIS

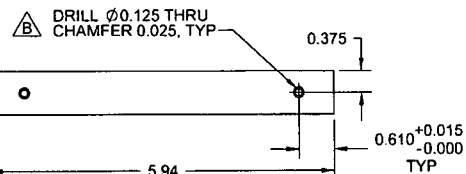
NOTES:

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs
D3443-3 = 0.35 lbs

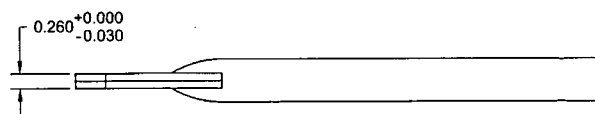
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09/08/25/14

W10 53502

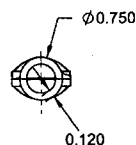
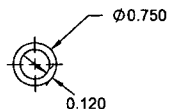
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|---|---|--|--------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | GP | DRAWING NO. | REV. C |
| MFG. APPR. |  | D3443 | SHEET 3 OF 4 |
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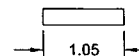
D3443-5 TUBING



D3443-7 TUBING



Ø0.210^{+0.005}_{-0.010}



D3443-9 PIN

D3443-9 NOTES:

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.025 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-5 = 0.41 lbs
D3443-7 = 0.62 lbs

RELEASED
07/08/25 MD

W/L 53502

| | | | |
|--|--------------------|--|--------------|
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| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 07 | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | D3443 | SHEET 4 OF 4 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | STRUT WELDMENT ASSEMBLY | NTS |
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